

Claims:

1. A cartridge containing one or more beverage ingredients
and being formed from substantially air- and water-
impermeable materials, the cartridge comprising an
outer member defining a storage chamber in which is
stored the one or more beverage ingredients, an inner
member having a discharge spout forming an outlet for
outflow of beverage formed from the one or more
beverage ingredients, and a filter disposed between the
storage chamber and the discharge spout, characterised
in that the inner member and filter are conjoined in
one operation to the outer member by means of at least
one weld.
2. A cartridge as claimed in claim 1 wherein the outer
member has an opening for accessing the storage
chamber, wherein the inner member and filter are
conjoined to the outer member at a base remote from the
opening.
3. A cartridge as claimed in claim 2 wherein the inner
member, outer member and filter are annular.
4. A cartridge as claimed in claim 3 wherein the weld is
substantially circular.
5. A cartridge as claimed in claim 4 wherein the inner
member and outer member are of plastics materials and
the at least one weld is an ultrasonically-formed weld.

6. A cartridge as claimed in claim 5 wherein the inner member comprises a frame and the at least one weld is formed round a periphery of said frame.
- 5 7. A cartridge as claimed in claim 6 wherein the frame comprises a plurality of webs extending upwardly from the frame towards a closed first end of the outer member to define one or more passages between the frame and the closed first end of the outer member and
10 wherein welds are formed between the webs and the closed first end of the outer member.
8. A method of manufacturing a cartridge containing one or more beverage ingredients and being formed from
15 substantially air- and water-impermeable materials, the cartridge comprising an outer member defining a storage chamber in which is stored the one or more beverage ingredients, an inner member having a discharge spout forming an outlet for outflow of beverage formed from
20 the one or more beverage ingredients, and a filter, the method comprising conjoining the inner member and the filter in one step to the outer member by means of at least one welding step.
- 25 9. A method as claimed in claim 8 wherein the welding step is by ultrasonic welding.
10. A method as claimed in claim 9 further comprising forming a first welding line around a periphery of the
30 inner member and filter.

11. A method as claimed in claim 10 further comprising forming a second welding line around the inner member and filter at or near the discharge spout.